

切削参数参考表 Recommended Milling Conditions

加工材料 Work Material			调质钢・淬火钢 Prehardened Steels・Hardened Steels NAK80・STAVAX・SKD61 (~52HRC)				淬火钢 Hardened Steels SKD11・ELMAX (~62HRC)				高速钢 High Speed Tool Steels SKH・HAP (~68HRC)			
刃径 Dia.	(R)角半径 Corner Radius	有效长 Effective Length	切深量 Depth of Cut		进给速度 Feed	主轴转速 Spindle Speed	切深量 Depth of Cut		进给速度 Feed	主轴转速 Spindle Speed	切深量 Depth of Cut		进给速度 Feed	主轴转速 Spindle Speed
			ap mm	ae mm	mm/min	min ⁻¹	ap mm	ae mm	mm/min	min ⁻¹	ap mm	ae mm	mm/min	min ⁻¹
0.5	0.1	1.5	0.008	0.2	1,500	50,000	0.005	0.15	800	50,000	0.003	0.1	600	50,000
		2.5	0.006	0.15	1,000	40,000	0.005	0.1	500	40,000	0.003	0.05	300	40,000
1.0	0.1 0.2	3	0.012	0.4	2,000	40,000	0.007	0.25	1,000	40,000	0.006	0.15	800	35,000
		5	0.008	0.3	1,500	30,000	0.005	0.15	800	30,000	0.004	0.1	400	25,000
1.5	0.1 0.2	4.5	0.015	0.6	2,500	35,000	0.008	0.4	1,200	35,000	0.007	0.2	1,000	30,000
		7.5	0.012	0.4	1,800	25,000	0.006	0.3	1,000	25,000	0.005	0.15	500	20,000
2.0	0.1 0.3	6	0.02	0.8	3,000	30,000	0.01	0.6	1,500	30,000	0.008	0.3	1,200	25,000
		10	0.015	0.6	2,000	20,000	0.008	0.4	1,000	20,000	0.006	0.2	600	18,000
备 注 Notes			※ 切深量是指进行等高线加工时的大概标准。请根据机床刚性和加工方法进行调整。 ※ 建议以倾斜切入方式进刀。请将此时的切入角度设定在3°以内。 ※ 预加工（中精加工）时请注意使精加工余量相对于加工面保持均匀。 ※ 加工R角等负载大的部位或复杂的形状时，请特别注意参数设定和刀路轨迹等。 ※ 请以相同的比率调整主轴转速和进给速度。 ※ 建议使用由雾冷却方式。 ※ Depth of cut is for contour line milling as the value of reference. Please adjust it depending on machine rigidity and processing method. ※ Ramping approach with angle 3° or smaller is recommended. ※ Recommend leaving uniform finishing allowance on the machined surface in the pre-stage cutting (semi-finishing). ※ When cutting high load sections or complex shapes, it requires attention to condition setting and tool path. ※ Adjust both spindle speed and feed at the same rate. ※ Oil mist coolant is recommended.											

CBN铣刀
Cube Boron Nitride钻石铣刀
Diamond平底铣刀
Square长颈平底
铣刀
Long Neck Square球头铣刀
Ball长颈球头
铣刀
Long Neck Ball圆鼻铣刀
Radius长颈圆鼻
铣刀
Long Neck Radius锥形铣刀
Taper锥形球头
铣刀
Taper Ball锥形圆鼻
铣刀
Taper Radius钻头
Drilling螺纹铣刀
Thread milling倒角刀
Chamfering